

Date: Monday, 11/08/2008 2:45:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW FRAME
Job Number	: 41133		
Estimate Number	: 10624		
P.O. Number	:	Part Number	: D2956
This Issue	: 11/08/2008 S.O. No. :	Drawing Number	: D2956 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36857	Material	:
Written By	:	Due Date	: 29/08/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUO 08.8.11</u>		
Comment	: Est. A00.01.14 New issue EC Est Rev:B Now on Waterjet 07-06-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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LB 8-8-20



Comment: Qty.: 3.3907 sf(s)/Unit Total: 33.9066 sf(s)

5052-H32 .040 Sheet

Material: 5052-H34 sheet 0.040" thick. ~~107813~~

Batch

107813

OUT of MAT

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2956

Dwg Rev: C

Prog Rev: C

LB 8-8-20

(7)

2-Deburr if necessary

LB 8-8-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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LB 8-8-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/08/20 (+7)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

LB 02/08/21 (+7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WINDOW FRAME

Job Number: 41133

Part Number: D2956

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m/08523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

FX 08/08/22

(7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/08/25

(7X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *207*

8/8/25

SP

(7X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



m 08.08.25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

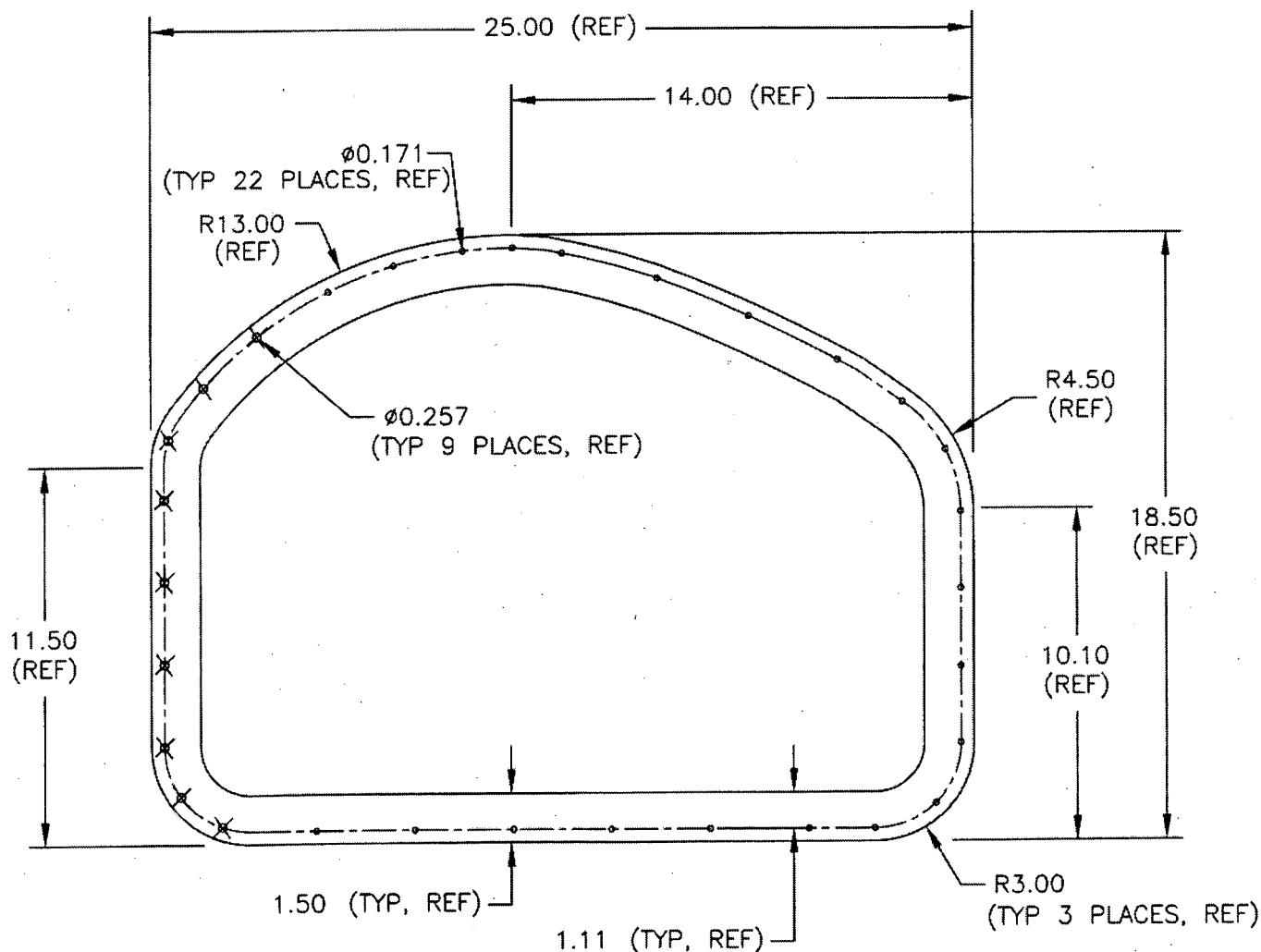
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2956	REV. C SHEET 1 OF 1
DATE 01.06.04		TITLE WINDOW FRAME	SCALE 1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	Ø0.141 HOLES WERE Ø0.128 (NCR 407)	
C	01.06.04	REMOVE Ø0.141 HOLES	

RELEASED
01.06.05



D2956 FLAT PATTERN

MACHINE PER DRAWING FILE "D2956-C1.DWG"
CHECK HOLES PER TEMPLATE DT8437
BEND PER TEMPLATE DT8567
MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK
FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41133

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